March 5, 1957 H. T. SUMNER 2,783,631

FULL-FASHIONED KNITTED GARMENT AND METHOD

Filed June 14, 1954 6 Sheets-Sheet 1

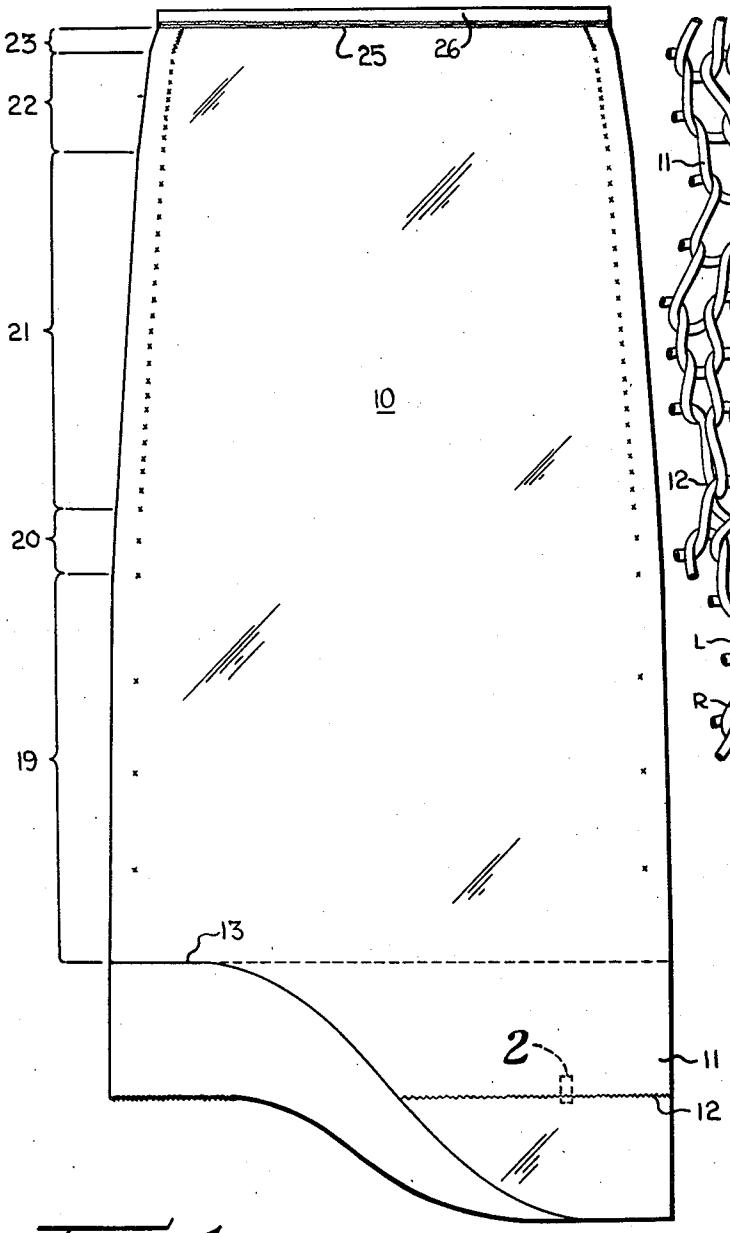


Fig-1

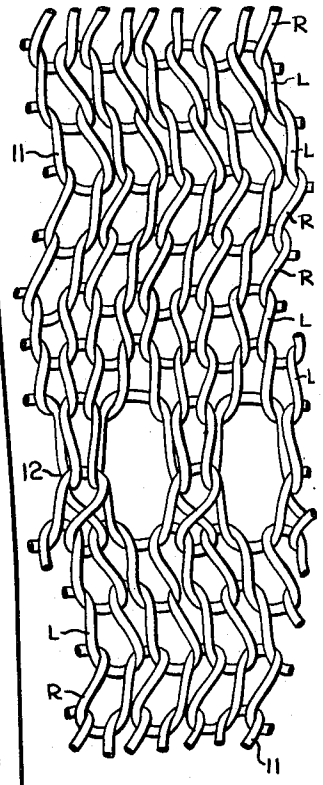


Fig-2

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FULL-FASHIONED KNITTED GARMENT AND METHOD

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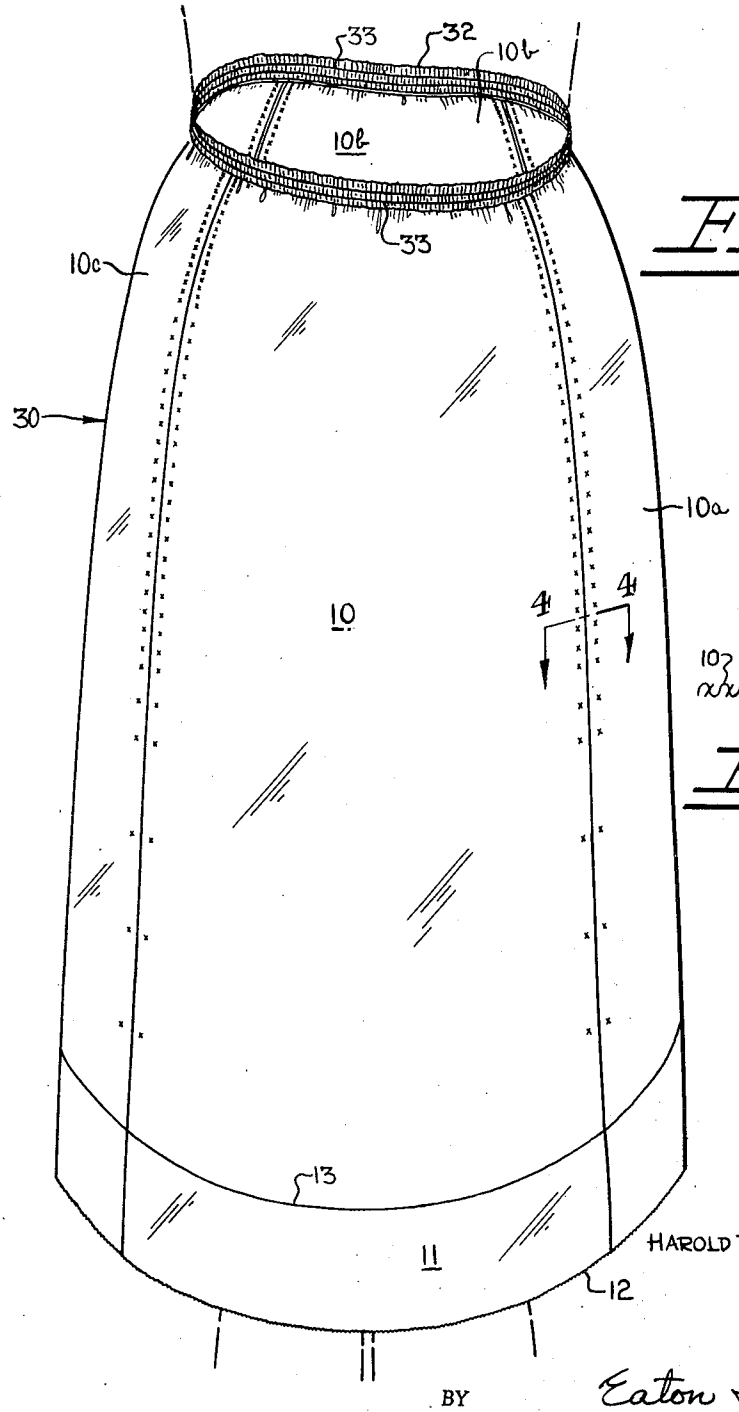


Fig-3

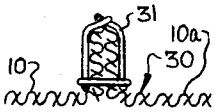


Fig-4

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FULL-FASHIONED KNITTED GARMENT AND METHOD

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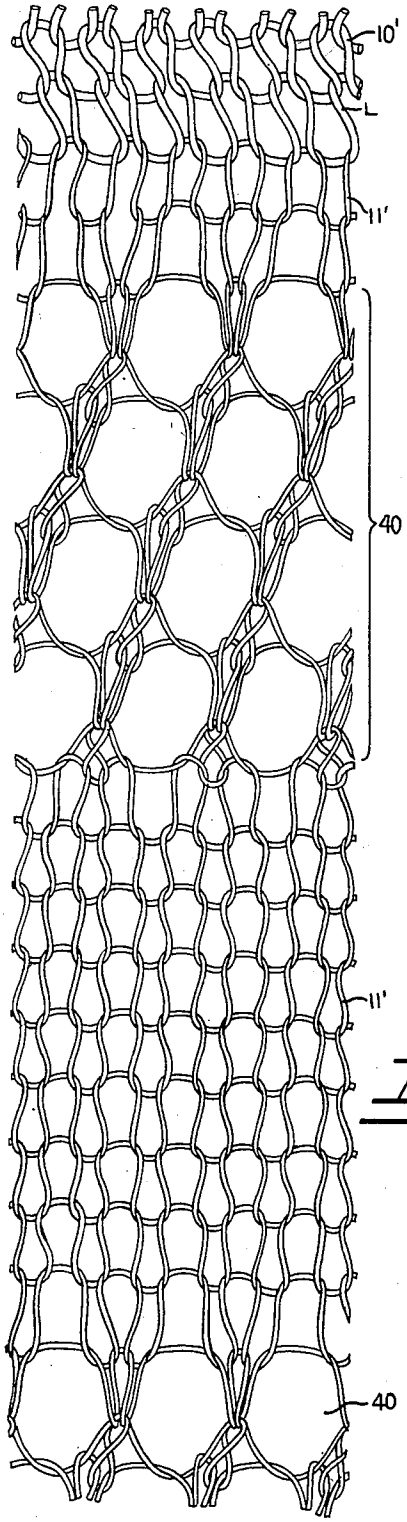


Fig-6

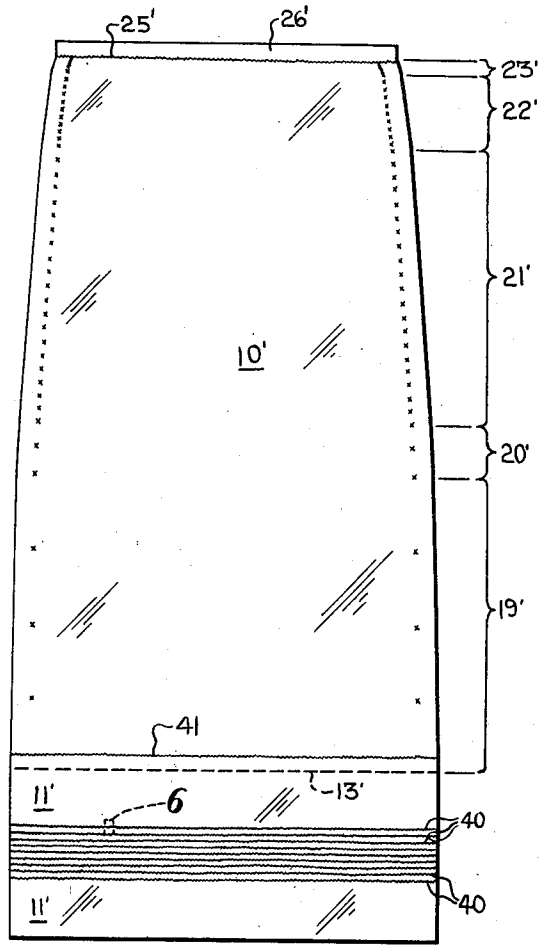


Fig-5

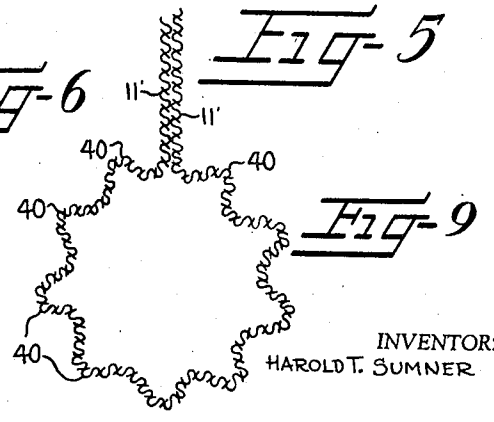


Fig-9

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FULL-FASHIONED KNITTED GARMENT AND METHOD

Filed June 14, 1954 6 Sheets-Sheet 4

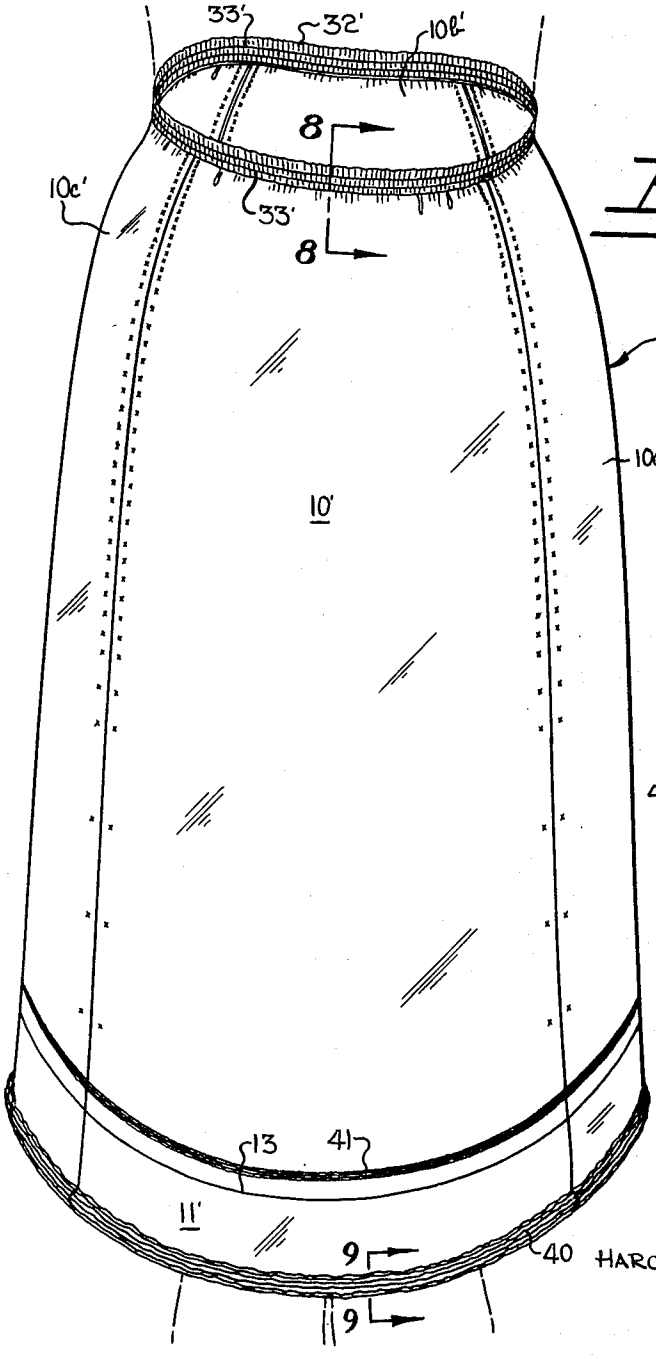


Fig-7

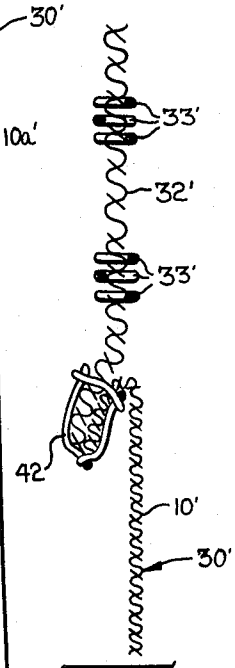


Fig-8

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FULL-FASHIONED KNITTED GARMENT AND METHOD

Filed June 14, 1954 6 Sheets-Sheet 5

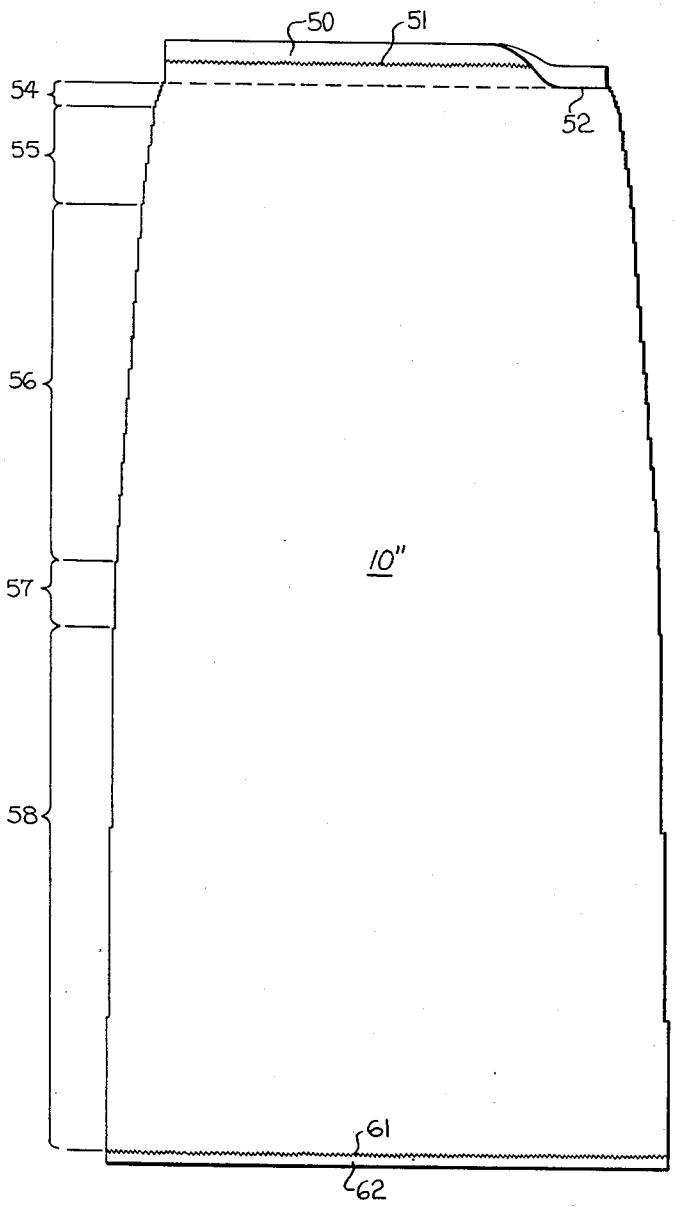


Fig-10

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FULL-FASHIONED KNITTED GARMENT AND METHOD

Filed June 14, 1954 6 Sheets-Sheet 6

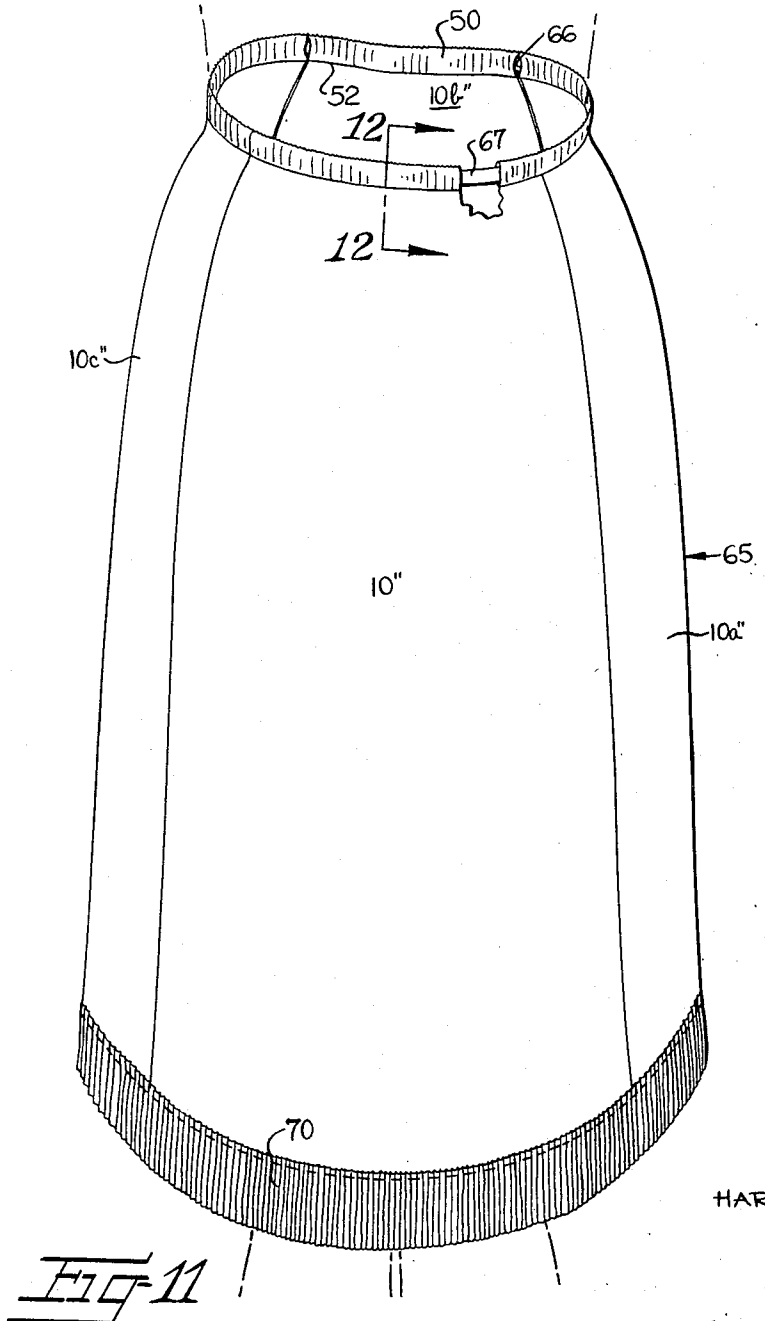


FIG-11



FIG-12

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United States Patent Office 2,783,631 Patented Mar. 5, 1957

2,783,631

FULL-FASHIONED KNITTED GARMENT AND METHOD

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Application June 14, 1954, Serial No. 436,368

24 Claims. (Cl. 66—177)

This invention relates to full-fashioned knitted articles and method of producing same on full-fashioned or flat bed machines, and more especially to a method of producing a full-fashioned skirt, half-slip, petticoat and the like.

It is an object of this invention to provide a method of producing a knitted half-slip which comprises knitting a plurality of panels or blanks on full-fashioned knitting machines and varying the width of said panels or blanks during knitting to fashion the same and then securing the selvages of said panels or blanks together to form a generally tubular garment.

It is another object of this invention to provide a skirt-like garment comprising a plurality of panels, each of which is knitted and fashioned on a full-fashioned knitting machine. The panels are secured to each other to form a tube which is fashioned so as to progressively narrow from the bottom to the top, resulting in a garment having the best possible fit.

It is another object of this invention to provide a skirt-like garment and method of producing same which reduces the waste and labor heretofore required in making garments wherein it has been necessary to cut material and sew it together to form a garment of this type. Heretofore, it has been necessary to cut a plurality of panels from large sheets of knitted material and these panels were then hemmed and sewn together, after which it was necessary to attach a waistband and skirtband.

In order for the finished garment to hand properly it was necessary to cut such material on the bias, which made the cutting operation more difficult and resulted in a great deal of fabric waste. Also, the labor involved in cutting and sewing panels of this type has been expensive.

According to the present invention, the skirt-like garment is formed from a plurality of knitted panels in the form of knitted blanks, each of which is knitted as a separate piece of fabric material having selvages which will not ravel and which are easily secured to the selvages of other panels as by seaming, which provides a neater and smaller joint than hemming and sewing. By fashioning each of the panels during the knitting thereof the curvature and shape of the resulting garment may be determined without the necessity of cutting fabric.

It is another object of this invention to provide a garment of the type described comprising a plurality of full-fashioned panels wherein two or more yarns are used in knitting the blank, and said yarns being twisted in opposite directions. The oppositely twisted yarns are knitted into alternate courses, or every two courses or more as may be desired, and this results in fabric that will hang straight and not have a tendency to twist or skew out of shape.

It is another object of this invention to provide a garment of the type described made of a plurality of full-fashioned panels wherein the lower edge of each panel is turned in the knitting operation and connected to the body

of the panel to form a welt or hem which eliminates the necessity of hemming the finished garment.

Some of the objects of the invention having been stated, other objects will appear as the description proceeds, when taken in connection with the accompanying drawings, in which—

Figure 1 is a plan view of a knitted blank comprising one of the panels for the skirt-like garment, showing the welt of hem portion thereof partially unfolded;

Figure 2 is an enlarged fragmentary view of the dotted line area 2 in Figure 1 showing particularly the line of picot stitches at the fold line of the hem or welt;

Figure 3 is an isometric view of a completed garment formed in accordance with this invention, showing the same as worn and indicating the wearer in broken lines;

Figure 4 is an enlarged sectional plan view taken along the line 4—4 in Figure 3;

Figure 5 is a plan view of a modified form of a knitted blank forming one of the panels of a garment and showing the welt or hem in unturned position;

Figure 6 is an enlarged fragmentary view of the dotted line area 6 in Figure 5;

Figure 7 is a view similar to Figure 3 but showing a garment made up of a plurality of blanks such as shown in Figure 5;

Figure 8 is an enlarged vertical sectional view taken along the line 8—8 in Figure 7;

Figure 9 is an enlarged vertical sectional view taken along the line 9—9 in Figure 8;

Figure 10 is a plan view of another modified form of knitted blank comprising one of the panels for a skirt-like garment, this view being similar to Figure 1 but wherein the blank is fashioned by widening instead of narrowing;

Figure 11 is an isometric view similar to Figure 3 but showing a garment made up of a plurality of blanks such as shown in Figure 10;

Figure 12 is an enlarged fragmentary vertical sectional view taken substantially along line 12—12 in Figure 11.

Referring more specifically to the drawings, there will be observed in Figure 1 a knitted blank 10 which is knitted on a full-fashioned or flat bed knitting machine and comprises one of a plurality of panels used in forming a skirt-like garment in accordance with this invention. As is well known in the full-fashioned knitting art, a full-fashioned knitting machine has a plurality of yarn carriers, not shown, which are reciprocated one or more at a time as desired to feed one or more yarns to a plurality of knitting needles, not shown, to cause the yarn or yarns to be knitted into a plurality of courses to form an elongated blank of fabric.

By actuating the yarn feed carriers as desired and by using one or more of the yarn feed carriers the width of the garment may be varied from time to time and if desired additional or reinforcing yarn may be introduced in various areas of the garment as desired. It is also known in the full-fashioned hosiery art to knit a portion of the blank and to then turn or fold this portion by means of a conventional welt turner or the like so as to form a hem at the beginning end of the blank, which hem is generally known as a welt in the hosiery art.

In making the skirt-like garment in accordance with this invention a plurality of elongated blanks are knitted on a full-fashioned knitting machine, and these blanks are narrowed from time to time in order to fashion the same and to vary the width thereof and a welt or hem is formed at one end of the blank which makes up the hem in the completed garment.

The manner of narrowing may be varied as desired in a particular garment and in some cases it may be desired to widen as well as narrow in order to fashion a particular panel.

By way of illustration, panel **10** is shown as comprising a blank which is four hundred seventy-six wales in width at the beginning thereof and wherein a welt portion **11** is formed of the full four hundred seventy-six wale width. The welt **11** is a double welt having one hundred ninety-eight courses in each ply and is divided by a row of transverse picot stitches **12** which provides a fold line to permit the welt **11** to be folded transversely along line **12** so as to cause it to lie smooth and flat. The welt **11** is attached to the body of the fabric as at **13** in a manner conventional in the full-fashioned hosiery art by the use of a welt turner or the like, such as illustrated in Patents 2,101,048 and 2,183,575, the welt can be turned manually by manipulating the old style welt bar.

After the welt has been knitted and turned to form a welt or hem the body portion of the panel **10** is knitted from bottom to top in Figure 1. As illustrated the blank is narrowed preferably one needle or wale on each side as at **19** every one hundred and fifty courses for a total of six hundred courses.

After the narrowings **19**, the blank **10** is additionally narrowed twice as at **20**, fifty courses apart. Then the blank **10** is narrowed more rapidly by narrowing once every twenty-five courses as at **21** for a plurality of twenty-two comprising five hundred and fifty courses and is then narrowed every fifteen courses as at **22** for a total of ten narrowings and one hundred and fifty courses.

The upper portion of the blank is then additionally narrowed every five courses as at **23** for a plurality of six narrowings. The number and spacing of the narrowings **19** to **23** may vary as desired in fashioning a particular blank.

After the narrowings **23**, three courses of picot stitches **25** are knitted and then a small plurality of additional courses (in this instance six courses) are formed as at **26** and the blank is pressed off of the needles. The number of picot courses **25** may vary and these courses serve as an anti-ravel device for stopping any raveling which might occur in the courses **26**. The courses **25** define the upper edge of the blank and the additional fabric **26** is either turned under when the waistband is attached thereto or is cut and trimmed from the panel as may be desired.

Referring to Figure 2, it will be observed that in the preferred form of the invention two different yarns are used in making the panel **10**, one yarn being a left-twist or Z twist yarn and the other being a right-twist or S twist yarn and these yarns are knit into alternate courses or alternate groups of courses so that the latent twist properties in the yarns will balance each other and result in a fabric which will hand vertically straight without skewing or curving. As illustrated in Figure 2, right-twist yarns R are knitted to form two courses, and then left-twist yarns L are knitted to form two additional courses. and these yarns are knitted alternatively throughout the body of the panel **10** as above noted. If desired, the yarns L and R may be alternated every course or every three courses or in any desired grouping arrangement, but groups of two courses are preferred.

Referring to Figure 3, there will be observed a garment broadly indicated at **30** made up of four panels like the panel **10** and indicated at **10**, **10***a*, **10***b*, and **10***c*. The selvages of each of the panels are secured to the selvages of next adjacent panel by seaming as indicated in Figure 4. Due to the fact that the panel selvages are non-raveling, it is not necessary to sew the same together with extra fabric material overlapping the seam and forming a flap or hem on the inside of the garment but the edges may be seamed together by suitable threads such as indicated at **31** in Figure 4 in a manner similar to the manner in which the selvages of a full-fashioned stocking blank are seamed together. This makes a small seam which gives a much better appearance and hangs better than the seam or hems heretofore used in garments of this type and results in a fabric saving.

It will be noted that the welt **11** of each of the blanks **10** forms a hem around the lower periphery of the completed garment **30**. A suitable waistband **32** is secured to the upper edges of the panels **10** and this waistband **32** preferably has elastic strands **33** therein and may be secured to the upper edges of the panels **10** in any desired manner as by sewing or by seaming the lower edge thereof to the upper edges of the panels **10**, **10***a*, **10***b* and **10***c*. As heretofore stated, the excess fabric comprising the courses **26** and the picot lines **25** may be taken up in the seaming or sewing operation or may be cut prior to or during the sewing or seaming of the band **32** to the upper portion of the garment. Any suitable type of waistband may be used and may be secured to the garment in any suitable fashion the elastic waistband **32** being shown by way of illustration only.

If desired, additional yarns may be knitted into the blank **10** at any desired points for purposes of reinforcing the blank or for ornamental purposes. For example, a heavier yarn or an additional reinforcing yarn may be used in the welt or hem area **11** to lend body to the garment. Also, lines of picot stitches may be inserted at various places in the garment for ornamental appearances if so desired.

Referring now to Figures 5–8, inclusive, there will be observed a modified form of the garment wherein a plurality of picot stitches are formed in the welt or hem area, which stitches result in an uneven, lace-like ruffled fabric border in the completed garment.

A fabric blank indicated at **10′** is knitted in a manner similar to that previously described for the blank **10** and the blank **10′** has a welt or hem area **11′** and the body portion thereof is narrowed progressively as at **19′** to **23′**, inclusive, as may be described, to fashion the panel in the manner previously described.

In this form of invention, the line of picot stitches **12** is omitted and in lieu thereof a plurality of lines of picot or lace-like loops or stitches **40** are longitudinally spaced at the center portion of the welt or hem area **11′** and these lines extend transversely of panel **10′**. As will be observed more specifically in Figure 6, each of the lines **40** comprises several courses of picot stitches, in this instance eight courses, separated by several courses of regular stitches, in this instance nine.

After the welt or hem **11′** has been knitted with a plurality of picot lines **40** therein the welt is folded and turned along a line extending transversely of the blank intermediate the picot lines **40** so that the lines of picot or lace-like stitches **40**, extend along the bottom edge of the panel on both the inner and outer surfaces.

When the welt or hem portion **11′** is turned, the end of the welt is tied back into the fabric as at **13′** forming a double ply welt or hem along the bottom edge of the panel. In subsequent finishing operations the lace-like stitches **40** remain loose and lacy and do not lie flat so that a ruffled appearance is present in the lower edge of the panel.

If desired, additional lines of picot or lace-like stitches **41** may be placed in the body of the panel **10′** adjacent the welt **11′** or in any other area desired for the purposes of ornamentation. In Figure 7, the lace area **41** is illustrated as being somewhat wider than shown in Figure 5.

Referring to Figure 7, there will be observed a half slip or skirt-like garment **30′** made up of a plurality of panels identical to the panel **10′** and for purposes of illustration being indicated at **10′**, **10***a′*, **10***b′*, and **10***c′*. These panels are secured together at their selvages by seaming so as to give a small, neat line of juncture, and a suitable waistband **32′** is secured to the upper edges of the panels making up the skirt. The waistband **32′** may be seamed or sewed to the upper edge of the panel and as will be observed more readily in Figure 8, by way of example, the waistband **32′** having elastic strands **33′** therein is attached to the upper edge of the panels by stitches **42** penetrating the proximate edges of the panels and the waistband and forming a seam at the juncture.

If preferred, the waistband may be secured by sewing or any desired manner. For example, an additional welt could be formed at the upper portion of the skirt and a loose band of elastic inserted in this welt or hem.

The loose, lace-like ruffled appearance at the lower edge of the garment is more clearly observed in Figures 7 and 9, it being noted that the upper portion of the hem or welt **11'** lies flat, after finishing, but the area made up of the lace-like or picot stitches **40** retains a ruffled, uneven appearance which presents a pleasing appearance.

After the garments have been completed by securing a plurality of panels together as indicated, they may be finished in any desired fashion in a manner similar to the finishing processes in the full-fashioned hosiery art. For example, the garments may be pre-boarded on a form and treated by heat and steam to pre-set and preshrink the yarn in the fabric to cause desired loop characteristics to be maintained. After the pre-boarding operation the garment may be dyed in any conventional manner and then put through a final boarding operation and again treated to heat and/or steam for additionally setting the loop formation of the yarns. The pre-boarding and final boarding does not affect the lacy-like or ruffled appearance of the picot stitches **40**. Any suitable softeners or finishers may be used. The blanks can also be pre-set before being seamed together.

Referring now to Figures 10, 11 and 12, there will be observed still another form of blank and the garment formed therefrom wherein the knitted blank shown in Figure 10 is indicated at **10''**. The blank **10''** is also knitted on a full-fashioned or flat bed knitting machine and may be of substantially the same shape as the blank **10** shown in Figure 1. The primary difference between the blanks **10** and **10''** lies in the fact that the blank **10** is knitted from bottom to top or from its wide end to its narrow end in Figure 1 while the blank **10''** in Figure 10 is knitted from top to bottom or from its narrow end to its wide end. It follows, therefore, that the blank **10''** is fashioned by widening whereas the blank **10** is fashioned by narrowing.

By way of example, a relatively narrow welt portion **50** is formed as a double welt which is divided by a row of transverse picot stitches **51** which provides a fold line to permit the welt **50** to be folded upon itself and then interknitted with the body of the fabric as at **52** in a conventional manner and wherein a welt turner or the like, such as illustrated in said Patents 2,101,048 and 2,183,575, may be used.

After the welt **50** has been knitted and turned to form a channel or hem, the body portion of the blank **10''** is knitted from top to bottom in Figure 10 wherein it is widened in successive courses and wherein the number of courses between successive widenings vary in substantially the proportions defined in the description given with respect to Figure 1, the areas corresponding to areas **23**, **22**, **21**, **20** and **19** in Figure 1 being indicated at **54**, **55**, **56**, **57** and **58** in Figure 10. Accordingly, a detailed description of the number of courses and the number of widenings in the areas **54–58** is deemed unnecessary.

After the desired length of fabric has been knitted to form the blank **10''** in the manner described, a few courses of picot stitches **61** are knitted and then a relatively small plurality of additional courses is formed as at **62** whereupon the blank is pressed off of the needles. The number of picot courses **61** may vary and these courses merely serve as an anti-ravel device for stopping any raveling which might occur in the courses **62**. The courses **61** define the lower edge of the blank **10''** and the additional fabric **62** is either turned under when a wide hem is attached thereto or it may be cut and trimmed from the panel as may be desired. The panel may be constructed substantially as described with respect to Figure 2.

The form of garment made up of panels like panel **10''** and shown in Figure 11 is broadly designated at **65**, the

panels in Figure 11 being indicated at **10''**, **10a''**, **10b''** and **10c''**. These panels may be assembled in the same manner as that described with respect to the form of invention shown in Figure 3 with the exception that the inturned portion of the welt **50** is not seamed or stitched together at the juncture of at least one adjacent pair of panels to provide an opening **66** for the insertion of an elastic band **67**. This band **67**, after being inserted in the channel formed by the turned welt **50** may be suitably stitched together at opposite ends thereof to form the waistband of the garment. The waistband **67** is shown by way of example only, since there are various other ways in which an elastic waistband can be formed in the upper end of the garment.

After the panels have been assembled or stitched together, a suitable ornamental hem strip **70** may be attached to the fabric **62**, at either its lower or upper edge, as desired and, of course, if the lower edge of the hem strip **70** is attached to the fabric **62**, then its upper edge would be stitched to the portions of the blanks **10''—10c''** along a line spaced above the row of picot stitches **61**.

It is thus seen that we have provided a skirt-like garment and method for making the same which comprises knitting a plurality of individually elongated blanks of fabric material while varying the width of said blanks during the knitting process so as to fashion the same and securing the proximate longitudinal edges of said blanks together to form a skirt-like garment such as a lady's underslip or half-slip.

In the drawings and specification there has been set forth a preferred embodiment of the invention and although specific terms are employed, they are used in a generic and descriptive sense only, and not for purposes of limitation, the scope of the invention being defined in the claims.

I claim:

1. That method of making a skirt-like garment having front, rear and side sections which comprises plain knitting an individual full-fashioned elongated fabric blank for each section, varying the width of said blanks during the knitting thereof, and then securing the longitudinal edges of said fabric blanks together to form a generally tubular garment.

2. A garment formed in accordance with the method of claim 1.

3. That method of making a skirt-like garment from a plurality of individual fabric blanks of elongated fabric each having a body portion and a welt portion, which comprises knitting a first plurality of courses for each blank to form the welt portion, then turning the welt portion and connecting its ends, then knitting an additional plurality of courses to form the body portion, varying the width of said blanks during the knitting thereof, and then securing the longitudinal edges of said fabric blanks together to form a tubular garment.

4. A garment formed in accordance with the method of claim 3.

5. That method of making a skirt-like garment having front, rear and side sections which comprises plain knitting an individual full-fashioned, selvaged, elongated fabric blank for each section, varying the width of said blanks during the knitting thereof, and then seaming the selvages of said fabric blanks together to form a tubular garment.

6. A garment formed in accordance with method of claim 5.

7. That method of making a full-fashioned skirt-like garment having front, rear and side sections which comprises plain knitting an individual full-fashioned, selvaged, elongated fabric blank for each section, varying the width of said blanks during the knitting thereof then seaming the proximate selvages of said fabric blanks together to form a tubular garment, and attaching a waist band to the upper edges of said blanks.

8. A full-fashioned garment formed in accordance with the method of claim 7.

9. That method of making a full-fashioned skirt-like garment having front, rear and side sections which comprises plain knitting an individual full-fashioned elongated panel for each section from at least two oppositely twisted yarns wherein alternate groups of courses are knitted with at least one of said yarns twisted in one direction and the other courses are knitted with at least one yarn twisted in a direction opposite to said first yarn, varying the width of each of said panels during the knitting thereof to fashion the same, and then securing the proximate longitudinal edges of said panels together.

10. A full-fashioned garment made in accordance with the method of claim 9.

11. That method of making a full-fashioned skirt-like garment having front, rear and side sections which comprises knitting an individual full-fashioned elongated panel for each section from at least two oppositely twisted yarns wherein some courses are knitted with at least one of said yarns twisted in one direction and the other courses are knitted with at least one yarn twisted in a direction opposite to said first yarn, varying the width of each of said panels during the knitting thereof to fashion the same, and then securing the proximate longitudinal edges of said panels together.

12. A full-fashioned garment made in accordance with the method of claim 11.

13. That method of making a full-fashioned skirt-like garment having front, rear and side sections which comprises knitting an individual full-fashioned, selvaged, elongated panel for each section by knitting alternate groups of courses in each panel from yarns twisted in opposite directions, varying the width of each of said panels during the knitting thereof to fashion the same, and then seaming the proximate selvages of said panels together.

14. A full-fashioned garment made in accordance with the method of claim 13.

15. That method of making a full-fashioned skirt-like garment of a plurality of interconnected independently knitted full-fashioned panels each having a body portion and a welt portion, which comprises knitting a first plurality of courses for each panel to form the welt portion, turning the welt portion and connecting its ends, then knitting an additional plurality of courses to form the body portion, fashioning the body portion by narrowing the same at points on each side during the knitting thereof, knitting at least one course of anti-ravel stitches adjacent the end of the body portion, and then securing the proximate selvages of a plurality of such panels together with the welt portions thereof in alinement.

16. A garment made in accordance with the method of claim 15.

17. That method of making a full-fashioned skirt-like garment of a plurality of interconnected independently knitted full-fashioned panels each having a body portion and a welt portion, which comprises forming each panel by knitting a first plurality of courses to form a portion of the welt portion, then knitting at least one course of lace-like stitches and then knitting an additional plurality of courses to form the rest of the welt portion, folding the welt portion along said course of lace-like stitches and connecting its ends, then knitting an additional plurality of courses to form the body portion, fashioning the body portion by varying its width during the knitting thereof, then knitting at least one course of anti-ravel stitches adjacent the end of the body portion, and securing the selvages of a plurality of such panels together.

18. A full-fashioned garment made in accordance with the method of claim 17.

19. That method of making a full-fashioned skirt-like garment of a plurality of interconnected independently knitted full-fashioned panels, each having a body portion and a welt portion, which comprises forming each panel by knitting a first plurality of courses to form a portion of the belt portion, then knitting a plurality of groups of courses of lace stitches, then knitting an additional plurality of courses to form the rest of the welt portion, folding the welt portion along a line intermediate the groups of lace stitches and connecting its ends, then knitting an additional plurality of courses to form the body portion and fashioning the body portion by narrowing the same at points on each side during the knitting thereof, then knitting at least one course of anti-ravel stitches adjacent the end of the body portion, and securing the proximate selvages of such panels together to form a tubular garment with the lace stitches forming a ruffle along the lower edge thereof.

20. A full-fashioned garment made in accordance with the method of claim 19.

21. That method of making a full-fashioned skirt-like garment of a plurality of interconnected independently knitted full-fashioned panels, each having a body portion and a welt portion, which comprises forming each of said panels by knitting a first plurality of courses to form a portion of the welt portion, then knitting a plurality of courses of lace stitches, then knitting a plurality of additional courses to form the rest of the welt portion, folding the welt portion intermediate the lace stitches and connecting its ends, then knitting an additional plurality of courses to form the body portion and knitting at least some portions of the panels with yarns twisted in opposite directions wherein at least one course is knitted with a yarn knitted in one direction and other courses are knitted with yarns twisted in the opposite direction, fashioning the body portion by varying the width thereof during the knitting process, then knitting at least one course of anti-ravel stitches adjacent the end of the body portion, and securing the proximate selvages of such panels together to form a tubular garment with the lace stitches adjacent the lower edge thereof.

22. A full-fashioned garment made in accordance with the method of claim 21.

23. That method of making a skirt-like garment which comprises knitting a plurality of individual fabric blanks of elongated fabric from a Z-twist yarn and an S-twist yarn disposed in alternating courses by knitting a first plurality of courses to form a welt, turning the welt and connectnig its ends, then knitting an additional plurality of courses to form a body portion, and securing the elongated edges of a plurality of such blanks together with the welts in alinement.

24. A garment formed in accordance with the method of claim 23.

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